LISTING OF THE CLAIMS

This listing of the claims will replace all prior versions and listings of claims in the application.

1-99. Canceled.

100. (New) A five layer stitchless seam comprising a first tape portion, a first substrate portion in contact with said first tape portion, a second tape portion in contact with said first substrate portion, a second substrate portion in contact with said second tape portion, and a third tape portion in contact with said second substrate portion to provide a flexible stitchless seam between the five layers.

101. (New) The seam of claim 100, wherein at least two of the tape portions are contiguous.

102. (New) The seam of claim 100, wherein at least one of the tape portions is multilayered.

103. (New) The seam of claim 100, wherein at least two of said tape portions and said substrate portions are the same materials.

104. (New) The seam of claim 100, wherein the first substrate portion and the second substrate portion are different materials.

105. (New) The seam of claim 100, wherein at least one of the substrate portions comprises a barrier layer.

106. (New) The seam of claim 105, wherein at least one of the substrate portions comprises a fabric.

107. (New) The seam of claim 105, wherein both the first substrate portion and the second substrate portion comprise a fabric.

108. (New) The seam of claim 100, wherein at least four areas of the first and second substrate portions are bonded in a cross-sectional area of the seam and wherein the seam has a strength greater than a sewn seam made with the same substrates.

109. (New) The seam of claim 100, wherein at least four areas of the first and second substrate portions are bonded in a cross-sectional area of the seam and wherein the tensile grab strength is at least about 85kg.

110. (New) The seam of claim 100, wherein the tensile grab strength is at least about 114 kg.

111. (New) The seam of claim 100, wherein the tensile grab strength is at least 135 about kg.

112. (New) The seam of claim 100, wherein the tensile grab strength is at least about 150 kg.

113. (New) The seam of claim 100, wherein the seam is a welded seam.

114. (New) A multilayer stitchless seam comprising a connecting bond formed between at least a first substrate and a second substrate and at least a first tape portion, a second tape portion, and a third tape portion, wherein the stitchless seam is a welded seam having a seam width, wherein the first substrate surface is contacted by the first tape portion across a bonding width that is greater than the seam width.

115. (New) The multilayer stitchless seam of claim 114, wherein the bonding width is greater than twice the seam width.

116. (New) The multilayer stitchless seam of claim 114, wherein the bonding width is at least about three times the seam width.

117. (New) The multilayer stitchless seam of claim 114, wherein at least four areas of the first and second substrates are bonded in a cross-sectional area of the seam and wherein the seam has a strength greater than a sewn seam made from the same substrates.

118. (New) The multilayer stitchless seam of claim 114, wherein at least four areas of the first and second substrates are bonded in a cross-sectional area of the seam and wherein the tensile grab strength is at least about 85kg.

119. (New) The multilayer stitchless seam of claim 114, wherein the tensile grab strength is at least about 114 kg.

120. (New) The multilayer stitchless seam of claim 114, wherein the tensile grab strength is at least 135 about kg.

121. (New) The multilayer stitchless seam of claim 114, wherein the tensile grab strength is at least about 150 kg.

122. (New) The multilayer stitchless seam of claim 114, wherein the bonding width is at least 1.6 mm.

123. (New) A multilayer stitchless seam comprising a first tape portion, a first substrate portion in contact with said first tape portion, a second tape portion in contact with said first substrate portion, a second substrate portion in contact with said second tape portion, and a third tape portion in contact with said second substrate portion to provide a flexible seam between the layers.

124. (New) The multilayer stitchless seam of claim 123, further comprising a third substrate portion.

125. (New) The multilayer stitchless seam of claim 123, wherein the seam is a welded seam.